

split

Work Order ID 147512

147512

Page 1

Thursday, June 09, 2016 8:46:11 AM

Item ID: D2360

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Litter Tie Down Bracket

Stop *NS2*

Start Date: 5/25/2016

Start Qty: 400

4

Cust Item ID:

Required Date: 6/8/2016

Req'd Qty: 400

4

Customer:

Reference:

Approvals: Process Plan: MLS

Date: JUN 10 2016

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2341	Rev #
-------	-------

D2360	Rev D
-------	-------

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: 12.65" Long

0.00

0.00

DAS
33
9-89
DAS
44
9-89
16-07-08

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio D2341 and Dwg D2341
2-Deburr

0.03

0.53

DAS
44
9-89
16-07-07

Thursday, June 09, 2016 8:46:11 AM

147512

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Litter Tie Down Bracket

Start Date: 5/25/2016 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 6/8/2016 **Req'd Qty:** 4.00 ***4***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

Memo

0.01

QC

Quality Control

130

QC8- Inspect parts - second check

0.00

130

Memo

0.01

OC

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

Memo

0.03

HandFinish

Hand Finishing

Work Order ID 147512

Thursday, June 09, 2016 8:46:11 AM

147512

Page 3

Item ID: D2360

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Litter Tie Down Bracket

Start Date: 5/25/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/8/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum	0.00							
150	<i>m 134798</i>					<i>10</i>	<i>16-07-13</i>		<i>34 9-89</i>
Powdercoat	Memo	0.03							
Powder Coating	START TIME: <i>9:55</i>								
	OVEN TEMPERATURE: <i>320</i>								
	FINISH TIME: <i>10:25</i>								
160	QC3- Inspect Part Finish	0.00							
160						<i>(10)</i>			<i>38 9-89</i>
QC	Memo	0.01							<i>JUL 14 2016</i>
Quality Control									
170	Small Fab	0.00							
170						<i>3x</i>			<i>17/02/02</i>
Small Fab	Memo	0.16							<i>DAS 36 9-89</i>
Small Fab	Assemble as per dwg D2360								

Open Holes
#D 246
DAS 22 9-89
16.09.15

Work Order ID 147512

Thursday, June 09, 2016 8:46:11 AM

147512

Page 4

Item ID: D2360**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Litter Tie Down Bracket**Start Date:** 5/25/2016 **Start Qty:** 4.00***4*****Cust Item ID:****Required Date:** 6/8/2016 **Req'd Qty:** 4.00***4*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				3			DAS 38 9-89 FEB 02 2017
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>St221</u> Memo	0.00 0.01				10 3			DAS 21 9-89 FEB 03 2017
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							DAS 21 9-89 FEB 03 2017

DAS
21
9-89

FEB 03 2017

Picklist Print

Thursday, June 09, 2016 8:46:14 AM

Page 1

Work Order ID: 147512

147512

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 5/25/2016

Required Date: 6/8/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev H 07.06.12 ecn 825 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R18

Purchased

No

170

Each

164.0000

1

✓ 10

AN526C1032R18

Screw

**

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

72

4523

72

ST327

92

108079

92

D2002-015

Manufactured

No

170

Each

18.0000

2

40
820
14828/ (18x)

**

DAS
36
9-89

DAS
6
9-89

D2002-015

Knob

Location

Loc Qty

Loc Code

GA

18

140144

18

155556 (2x)

D2345

Manufactured

No

170

Each

19.0000

1

410

**

DAS
6
9-89

D2345

Lock Channel

Location

Loc Qty

Loc Code

GA

19

133107

2

136913

5

144888

12

77 DAS
36
9-89

SEP 14 2016

DAS
36
9-89

151355

(30)

Picklist Print

Thursday, June 09, 2016 8:46:14 AM

Work Order ID: 147512

147512

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 5/25/2016

Required Date: 6/8/2016

Start Qty: 4.00

Required Qty: 4.00

D2366 Manufactured No

170 Each 26.0000 2 ~~8~~ 20

D2366

Lock Handle

DAS

6

9-88

Location

Loc Qty

Loc Code

GA 20

144887 20

ST006 6

~~141094~~ 6

D2367 Manufactured No

170 Each 17.0000 1

D2367

Handle Knob

DAS

6

9-88

Location

Loc Qty

Loc Code

ST006 17

140046 17

D2372 Manufactured No

170 Each 30.0000 2

D2372

Quick Release

DAS

6

9-88

Location

Loc Qty

Loc Code

GA 30

140024 9

140773 8

141231 3

143531 10

D2373 Manufactured No

170 Each 18.0000 1

D2373

Spring

DAS

6

9-88

Location

Loc Qty

Loc Code

GA 18

140106 8

144889 10

Picklist Print

Thursday, June 09, 2016 8:46:14 AM

Work Order ID: 147512

147512

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 5/25/2016

Required Date: 6/8/2016

Start Qty: 4.00

Required Qty: 4.00

D2444

Manufactured No

170 Each

18.0000

1

**

D2444

Pip Pin Assembly

Location

Loc Qty

Loc Code

GA

18

141073

2

141608

6

144897

10

D6201

Manufactured No

100 f

15.5840

1.054

4.437895

**

D6201

"T" Extrusion

Location

Loc Qty

Loc Code

MAT028

15.5840001

124165

0.0000001

137533

11.734

141301

3.85

MS20470AD3-4

Purchased No

170 Each

1,188.000

1

**

MS20470AD3-4

Rivet, Universal Head

Location

Loc Qty

Loc Code

GA

268

111477

268

ST310

920

111477

920

SEP 11 2016

147972 (2) DAS 36 9-89
148314 (4) DAS 36 9-89

DAS

33

9-89

DAS

44

9-89

16-07-08

7,422' + 1.054'

3,175'

4 10

DAS 36 9-89

SEP 11 2016

Picklist Print

Page 4

Thursday, June 09, 2016 8:46:14 AM

Work Order ID: 147512

147512

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 5/25/2016

Required Date: 6/8/2016

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

170

Each

1,895.000

3

~~12~~ 30

MS21042L3

Nut

135135-112

135407-X78

DAS

6

9-88

Location

Loc Qty

Loc Code

FP001

44

m133790

44

GA

269

m133790

3

m134360

266

OVER007

600

m134754

600

ST303

982

m134039

12

m134634

170

m134943

800

MS27039-1-13

Purchased

No

170

Each

664.0000

1

~~4~~ 10

MS27039-1-13

Screw

DAS

6

9-88

Location

Loc Qty

Loc Code

GA

80

124326

80

over006

295

124326

295

ST280

289

125654

289

SFP 1 4 2016

Picklist Print

Page 5

Thursday, June 09, 2016 8:46:14 AM

Work Order ID: 147512

147512

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 5/25/2016

Required Date: 6/8/2016

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-15

Purchased

No

170

Each

345.0000

2

820

MS27039-1-15

Screw

Location

Loc Qty

Loc Code

GA

21

m127916

21

over006

100

m134852

100

ST280

224

m132640

224

NAS1149D0332J

Purchased

No

170

Each

1,258.000

8

32 80

NAS1149D0332.J

Washer

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

22

m134502

22

ST260a

1200

m134738

600

m134848

600

ST264

30

m134502

30

DAS
6
9-88

820

135530

80

DAS
6
9-88

SEP 14 2016

Thursday, June 09, 2016 8:46:15 AM

Shop Packet Print

Page 5

Picklist Print

Page 6

Thursday, June 09, 2016 8:46:15 AM

Work Order ID: 147512

147512

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 5/25/2016

Required Date: 6/8/2016

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

170

Each

1,571.000

2

8 20

NAS1149D0363.J

Washer

135294 x 77

DAS
6
8-89

Location

Loc Qty

Loc Code

GA

465

m134055

465

ST263

1106

m134606

106

m134676

1000

NAS679A3W

Purchased

No

170

Each

252.0000

1

4 10

NAS679A3W

Nut

Location

Loc Qty

Loc Code

GA

130

1463

5

M2409

125

Mezz

122

2409

122

DAS
SEP 14 2016
8

DART AEROSPACE LTD		Work Order: 147512
Description: Litter Tie Down Bracket (Locking)		Part Number: D2341
Inspection Dwg: D2341	Rev: 46 <i>6/14</i>	Page 1 of 1

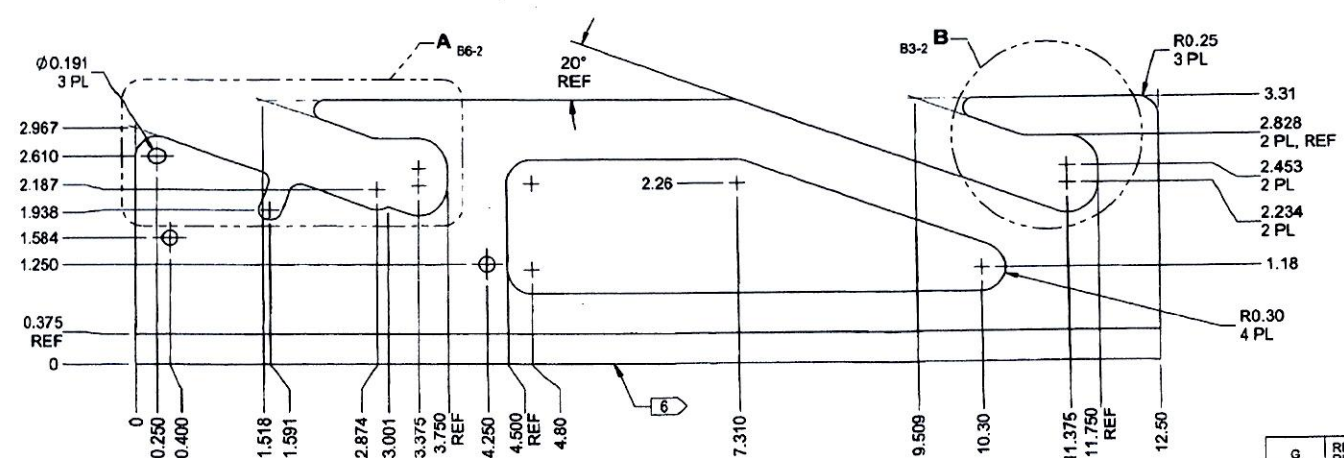
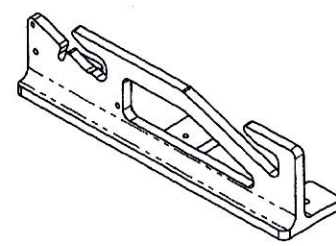
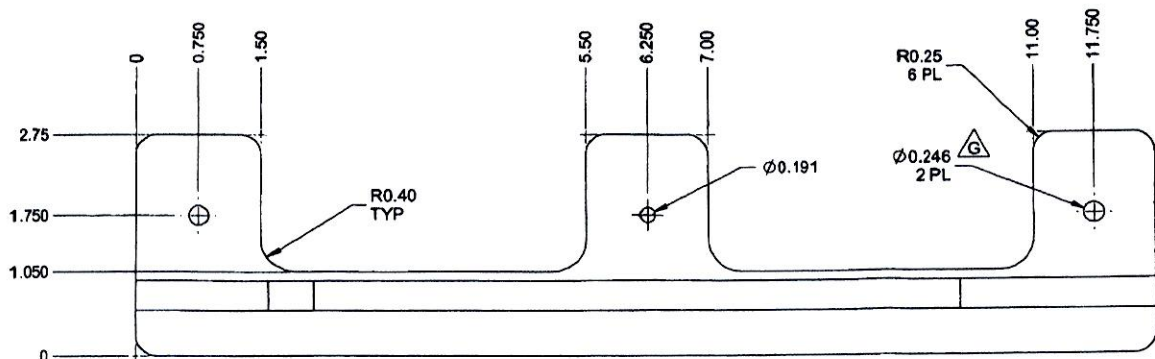
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.750	/		Vern	Fk-04
2.75	+/-0.030	2.754	/			
Ø0.242 Ø0.246	+0.005/-0.001	.246	/			
Ø0.191	+0.005/-0.001	.191	/			
R0.25	+/-0.030	.25	/		R-G.	
R0.40	+/-0.030	.40	/		R-G.	
12.50	+/-0.030	12.50	/		Tape	Fk-05
11.750	+/-0.010	11.750	/		"	"
11.00	+/-0.030	11.00	/		Vern	Fk-08
7.00	+/-0.030	7.00	/		"	"
6.250	+/-0.010	6.250	/		"	"
5.50	+/-0.030	5.50	/		Vern	Fk-04
1.50	+/-0.030	1.50	/			
0.750	+/-0.010	.750	/			
0.400	+/-0.010	.400	/			
1.584	+/-0.010	1.586	/			
2.610	+/-0.010	2.612	/			
0.250	+/-0.010	.250	/			
0.844	+/-0.010	.844	/			
Ø0.250	+/-0.010	.248	/			
0.750	+/-0.010	.750	/			
3.313	+/-0.010	3.310	/			
4.250	+/-0.010	4.250	/			
1.250	+/-0.010	1.250	/			

Measured by: 44 9-89	Audited by: <i>[Signature]</i> 3-4 9-89	Prototype Approval:	N/A
Date: 16-07-07	Date: 16-07-09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	



147512 M5
1000670

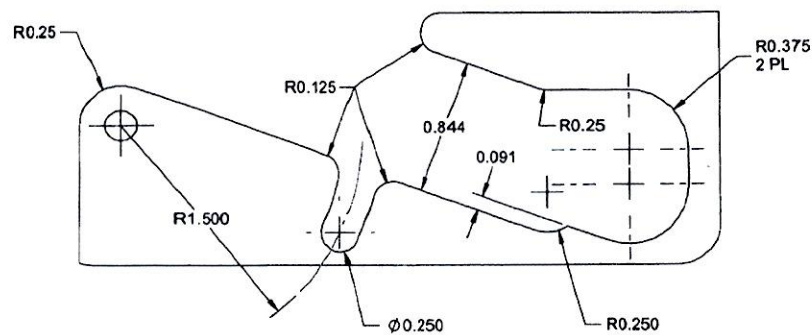
D2341 LITTER TIE DOWN BRACKET (LOCKING)

- NOTES:**
- 1) MATERIAL: MAKE FROM D6201-125 EXTRUSION
REF. 6061-T6/T651 PER QQ-A-200/8
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2341" AND B/N "BXXXXXX" ON BOTTOM FACE PER QSI 044 6.1
 - 7) WEIGHT: 1.64 lbs

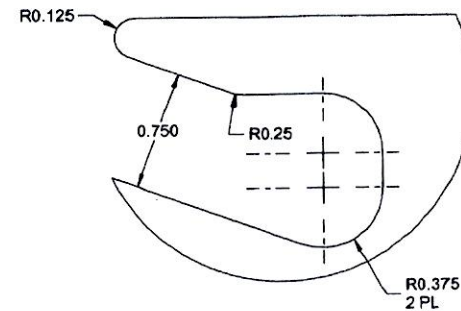
RELEASED
2016-04-18
2016-04-18

APPROVED

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AJS	DRAWING NO.	REV. G
MFG. APPR.	JLM	D2341	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LITTER TIE DOWN BRACKET (LOCKING)	NTS
DATE	15.11.12	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DETAIL A C6-1
SCALE 2X



DETAIL B C4-1
SCALE 2X

RELEASED
2016-04-18

APPROVED

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. G
MFG. APPR.	JLM	D2341	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LITTER TIE DOWN BRACKET (LOCKING)	NTS
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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

RELEASED

07.06.07 **[Signature]**

PARTS LIST:

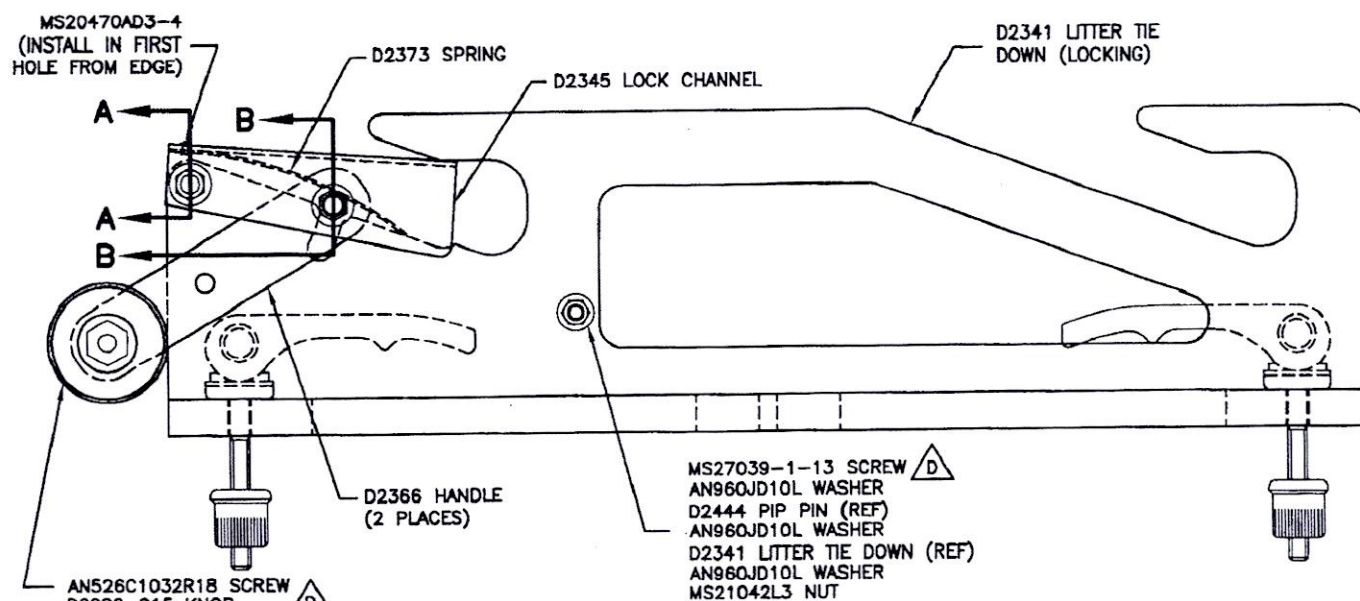
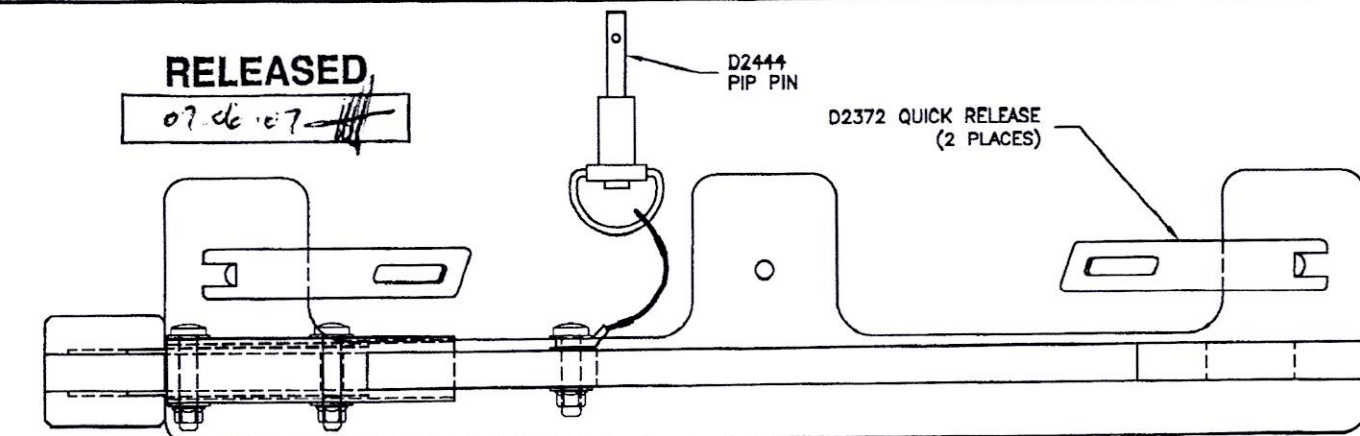
QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

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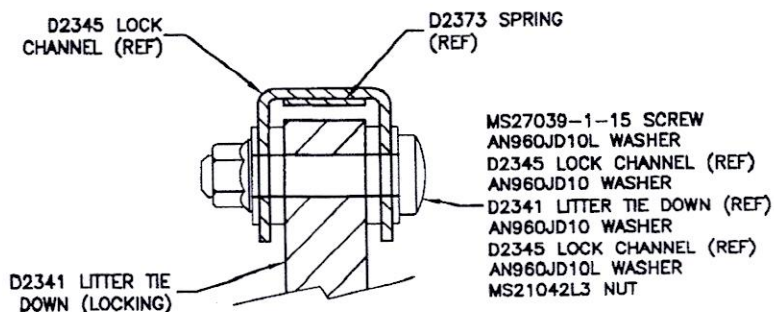
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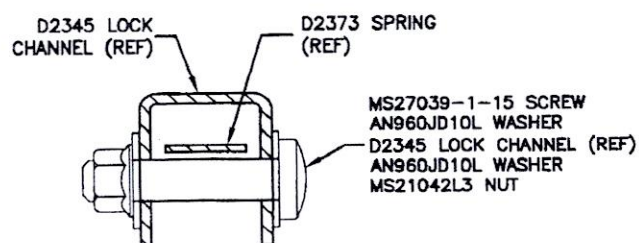
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2360	REV. D SHEET 2 OF 2
DATE 07.06.06	TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS		



D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)



SECTION A-A
(SCALE 1:1)



SECTION B-B
(SCALE 1:1)

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